

Order ID 67180



Page 1

Wednesday, March 09, 2011 12:59:51 PM

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: RF Date: 11-03-9 Tooling:  Date: 

Run Start

QC:  Date:  SPC (Y/N):  Date: 

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4168	A
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11N-D350-636	H
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0.00

100



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. *section R-R*

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting *section R-R*

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 *Detail J*

6- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-4 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clécko DT8863B on second side of tube and drill pilot holes for detail K:

\*\*\*SECOND SIDE\*\*\*

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" tab

8- Open up holes for Detail K to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D4168. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201 iplace per side *open holes at detail M section R-R to 0.500 according 4/16/8*

10- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left

*BE 11/03/30*

*BB 11/03/16*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Item ID:	D350-636-016	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Skidtube STD w/ Training Wearplates, RH					
Start Date:	3/9/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/16/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	from bending as per QSI 004 A/R Aluminum Rod batch: <input type="checkbox"/> M116577		BE	11/03/30					
	11-Grind welds flush as per Dwg D4168	BE 11/03/30							
120	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 11/03/31

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BL 11-3-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D4168.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)  
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168  
(welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291 batch: 116948  
exp. date: 12/01/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004  
(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod batch: 1116577

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D4168

BE 11/04/04

PA 7

BE 4/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-016 PAR #: N/A Fault Category: Skid tubes NCR: Yes No DQA: 1A Date: 11.04.21  
 Resolution: Rework Disposition: Rework QA: N/C Closed: OK Date: 11/04/25

NCR: 67180		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/06	#160	While Drilling out the 25th hole from aft. to Pilot for the counter bore brake cover it be off center.	GP 11.04.06 PS/04	DRAW OUT AND REPLACE CROSS BOLT SPACER. 4170-1 B 66158 (1P)	BE 11/04/06 S 11/04/06	GP 11.04.06 PS/04	S 11/04/06	
		R.C. Process						

NOTE: Date & initial all entries

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Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D4168

12- C'bore section CH-CH

13- Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 67180

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Start Date: 3/9/2011 Start Qty: 1.00



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Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  HandFinish	Pressure Wash per QSI005 4.3	0.00				1		BR 11-4-7	
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00							
200  Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1		BR 11-4-7	
Powder Coating	Memo START TIME: 3:45 OVEN TEMPERATURE: 320° FINISH TIME: 4:15	0.00							
210  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo Inspect for foreign object per QSI 024	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 67180**

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Start Date: 3/9/2011 Start Qty: 1.00

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
230	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: <u>116918</u> EXP DATE: <u>12/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>114189</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				<u>40</u>			
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00							<u>Pap/s</u>
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00				<u>64</u>			

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-016 Location: _____ PPP rev: _____								
280 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

CK 11/04/08  
CMF  
11-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH




Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1  Cross Bolt Spacer		Manufactured	No			160	Each	61.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		61							
				59424		3							
				62450		48							
				64005		10							
D3490-3  Cross Bolt Spacer		Manufactured	No			160	Each	35.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		35							
				60294		1							
				63556		24							
				64006		10							
AN3C34A  BOLT		Purchased	No			230	Each	70.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST353		70							
				116003		20							
				116075		50							

*BE 104/05*

*BE 104/05*  
*B 66968 x4*

*W 11.04.08*

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

40.0000

4

4



BOLT



11  
ml 11.04.08

B# 111925

## Location

## Loc Qty

## Loc Code

FG	10	
116590	10	
ST353	30	
109771	6	
116381	2	
116590	22	

AN3C37A

Purchased

No

230

Each

81.0000

1

1



BOLT



11.04.08

## Location

## Loc Qty

## Loc Code

ST353	1	
114801	1	
ST354	80	
116874	30	
117010	50	

AN3C42A

Purchased

No

230

Each

61.0000

1

1



BOLT



11.04.08

## Location

## Loc Qty

## Loc Code

ST354	61	
106176	61	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

10.0000

1

1



Blade Fitting Assembly, RH



ml 11.04.08

## Location

## Loc Qty

## Loc Code

FP008

9

59643

1

62003

8

FP18

1

61690

1

D3492-1

Manufactured No

230

Each

0.0000

8

8



Plug

B#66937



ml 11.04.08

D3492-3

Manufactured No

230

Each

0.0000

8

8



Plug

B#66931



ml 11.04.08

D3873-1

Manufactured No

230

Each

180.0000

7

7



Bushing



ml 11.04.08

## Location

## Loc Qty

## Loc Code

ST088

180

57615

3

62197

8

64567

69

64760

100

D4154-041

Manufactured No

230

Each

2.0000

1

1



Wearplate Assembly



ml 11.04.08

## Location

## Loc Qty

## Loc Code

FG

2

65092

2

B66228

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 12:59:59 PM

Page 4

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D4170-1 Manufactured No

230 Each

38.0000

4 4



Bushing

Location

Loc Qty

Loc Code

LG

38

62251

4

65912

23

66158

11

D4171-1 Manufactured No

230 Each

18.0000

1 1



Bushing

Location

Loc Qty

Loc Code

ST135

18

65646

18

MS21043-3 Purchased No

230 Each

1,156.000

5 5



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1080

112314

1080

NAS1149C0363R Purchased No

230 Each

5,076.000

9 9



Washer

Location

Loc Qty

Loc Code

ST297

5076

113524

33

113889

139

114742

4904

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 12:59:59 PM

Page 5

Work Order ID: 67180



Parent Item: D350-636-016



Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

300.0000

4

4



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

260

111819

34

113362

226

NAS1611-010

Purchased

No

230

Each

309.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

243.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

243

115460

100

115589

28

115812

20

116582

95

B# 117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 1:00:00 PM

Page 6

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD816

Purchased

No

250

Each

85.0000

2

2



1/2" washer, Alum

Location

Loc Qty

Loc Code

ST348

85

106043

85

D2744

Manufactured

No

110

Each

55.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

29

65086

29

ST

26

62715

26

D26003-BENT

Manufactured

No

110

Each

6.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

6

61634

2

62764

1

64434

3

66875

106043

BE 11/03/30

BB 11/03/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, March 09, 2011 1:00:00 PM

Page 7

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

122.0000 8 8



Crossbolt Spacer



BE11/04/09

Location

Loc Qty

Loc Code

LG

122

50281

10

57953

2

59111

10

61844

16

64003

84

8

D2739

Manufactured No

160 Each

4.0000 1 1



350 I Beam



BE11/04/04

Location

Loc Qty

Loc Code

LG

4

64448

4

B 66981

1

ALS4-1032-225

Purchased No

230 Each

3,809.000 4 4



Insert



11 04 08

Location

Loc Qty

Loc Code

PK011

3809

110768

3809

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 1:00:00 PM

Page 8

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

59.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST345

25

116874

25

ST346

34

114442

5

115188

5

115960

24

AN6C44A

Purchased

No

230

Each

89.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

87

111649

2

114653

1

115936

34

116874

50

MS21083C8

Purchased

No

230

Each

57.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST303

57

113845

5

114934

3

115594

4

115884

25

117010

20

11.04.08

11.04.08

11.04.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 1:00:00 PM

Page 9

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230 Each

228.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST072

228

63647

128

66959

100

AN960C10L NAS1149C0332 Purchased

No

230 Each

61.0000

4

4



washer

B# 117291

Location

Loc Qty

Loc Code

ST297

61

107534

59

108246

2

D2745 Manufactured No

230 Each

105.0000

8

8



Bushing

Location

Loc Qty

Loc Code

ST021

105

52311

5

59112

4

63315

96

AN960C816L Purchased

No

230 Each

0.0000

1

1



WASHER

NAS1149C0332

W114915

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 1:00:01 PM

Page 10

Work Order ID: 67180

Parent Item: D350-636-016


Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011


Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 327.0000 4 4  
  
 BOLT


m/l 11.04.08

Location	Loc Qty	Loc Code
ST351	327	
111982	102	
116419	75	
116549	50	
116704	100	

MS21043-6 Purchased No 230 Each 538.0000 4 4  
  
 NUT


m/l 11.04.08

Location	Loc Qty	Loc Code
ST301	538	
112314	538	

D3493-1 Manufactured No 250 Each 28.0000 2 2  
  
 Washer

2 m/l 11.04.08

Location	Loc Qty	Loc Code
ST062	28	
62677	28	

MS21083C8 Purchased No 250 Each 57.0000 2 2  
  
 NUT

m/l 11.04.08

Location	Loc Qty	Loc Code
ST303	57	
113845	5	
114934	3	
115594	4	
115884	25	
117010	20	

Wednesday, March 09, 2011 1:00:01 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, March 09, 2011 1:00:01 PM

Page 11

Work Order ID: 67180

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

67.0000

2

2



BOLT



11 04 08

## Location

## Loc Qty

## Loc Code

ST345

67

113558

1

114653

2

115723

4

116381

60

D2741

Manufactured

No

250

Each

77.0000

1

1



Blade, 350 Skidtube

## Location

## Loc Qty

## Loc Code

ST466

77

60210

4

61341

33

63589

40

11/04/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
8	8	8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	ANBC44A	BOLT
1	1	1	1	ANBC35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN980C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47180

*11-03-9*

#### GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEX DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

**RELEASED**  
2010-09-15

A		NEW ISSUE		SC	10.08.09
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED	SC	DRAWING NO.	REV. A		
MFG. APPR.		D4168	SHEET 1 OF 11		
APPROVED		TITLE	SCALE		
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS		
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

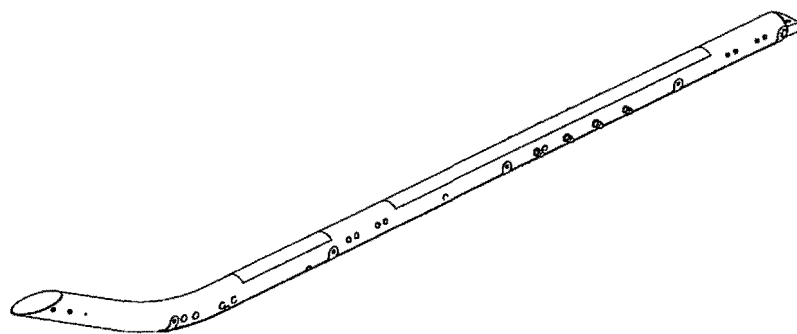
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

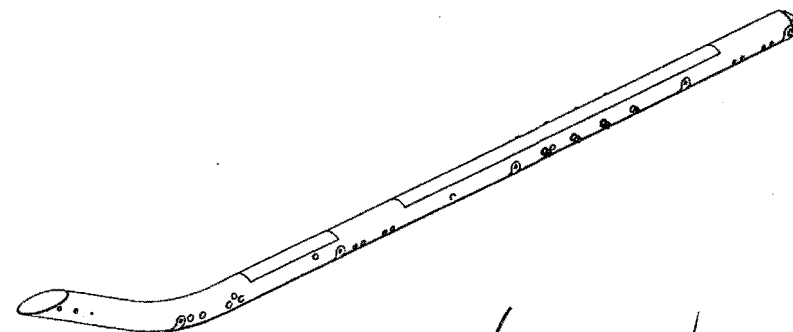
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

*u104218d*

**RELEASED**  
2010-09-15  
JW

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4168</b>	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>10.08.09</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

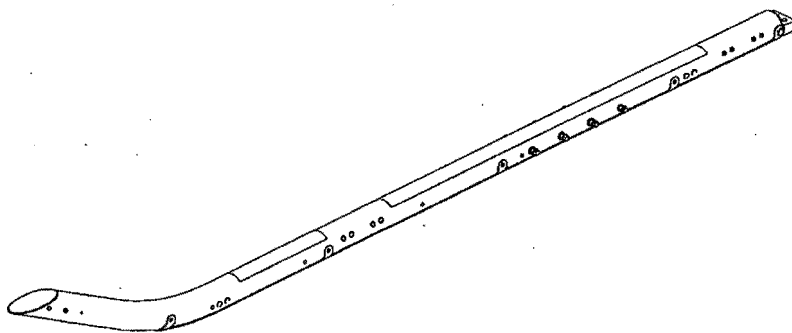
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

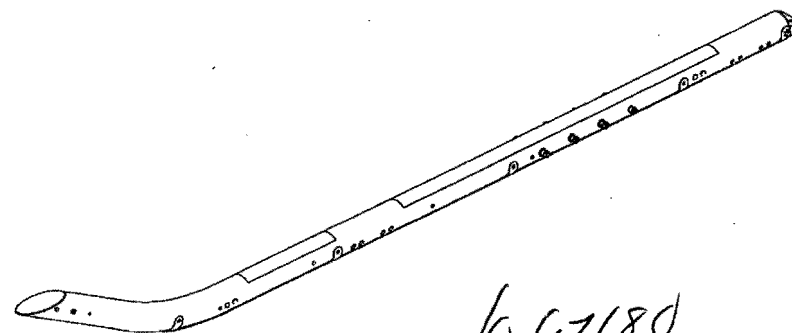
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

*u/b 47180*

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

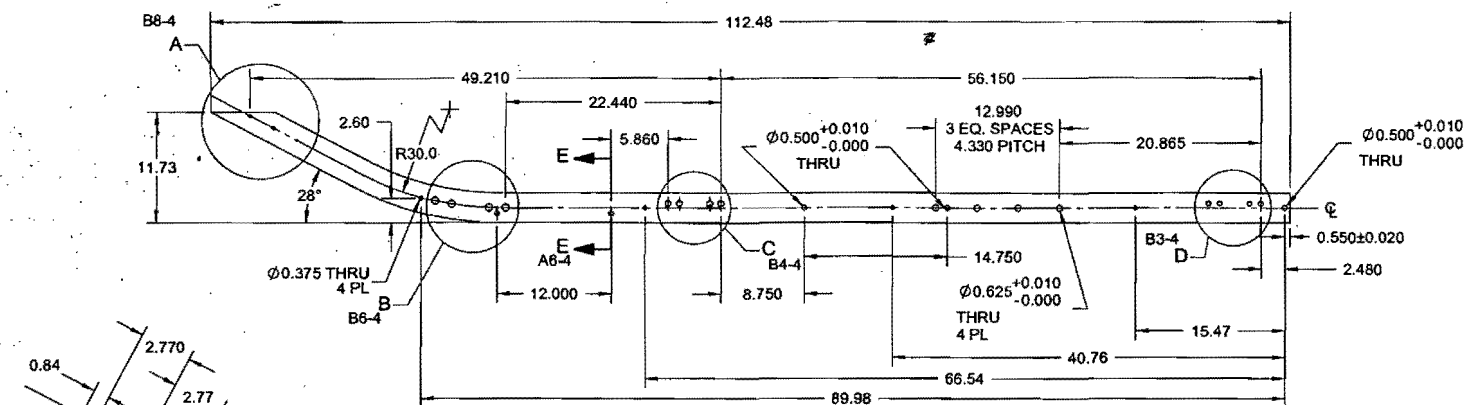
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

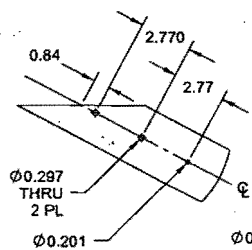
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

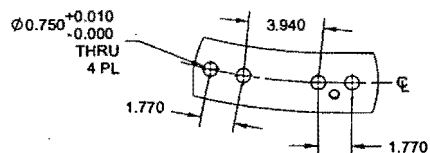




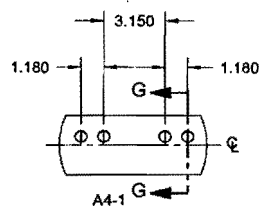
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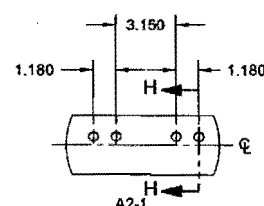
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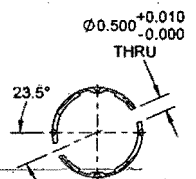
**DETAIL B**  
SCALE 2X



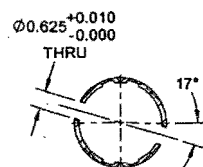
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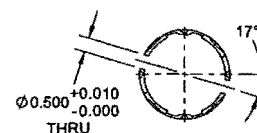
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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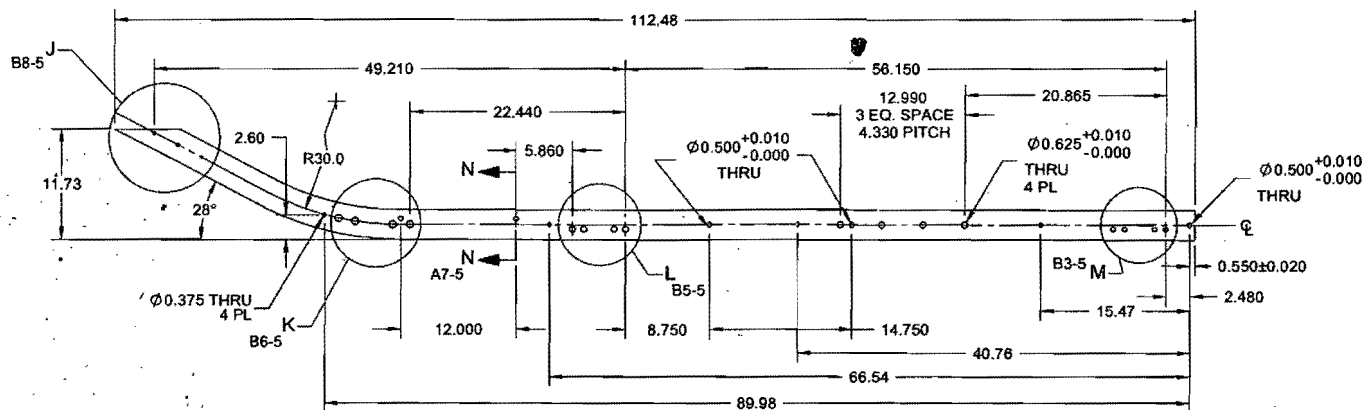
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

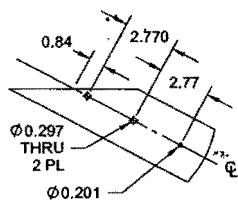
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**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

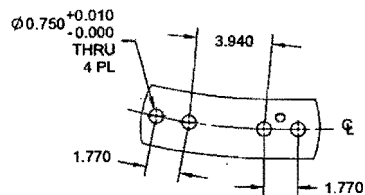
**NOTE:** Date & initial all entries



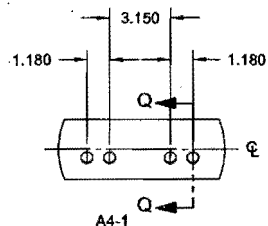
**D4168-2 RH SKIDTUBE**



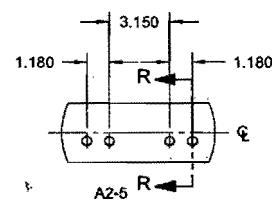
**DETAIL J**  
SCALE 2X



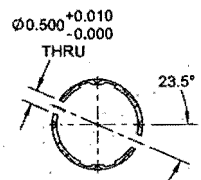
**DETAIL K**  
SCALE 2X



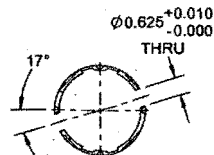
**DETAIL L**  
SCALE 2X



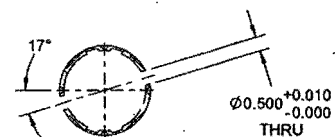
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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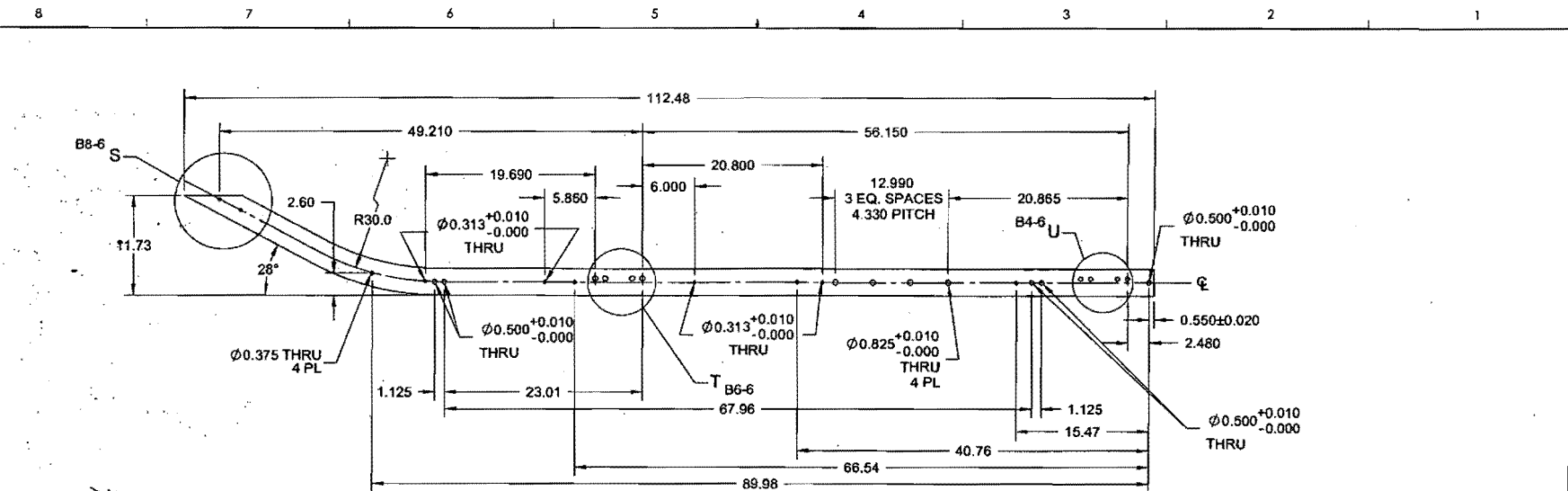
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

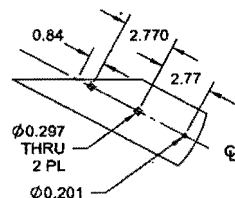
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

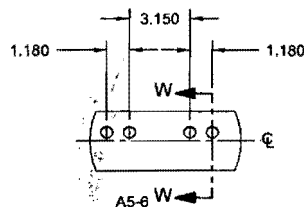
**NOTE:** Date & initial all entries



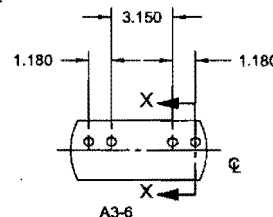
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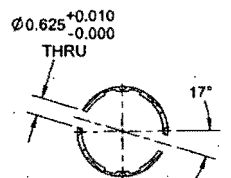
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D8-6  
SCALE 2X



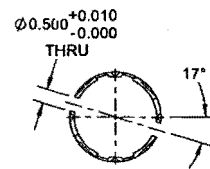
**DETAIL T**  
C5-6  
SCALE 2X



**DETAIL U**  
D3-6  
SCALE 2X



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

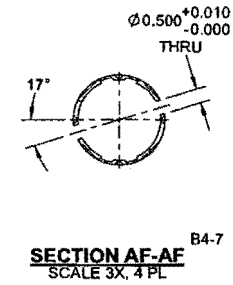
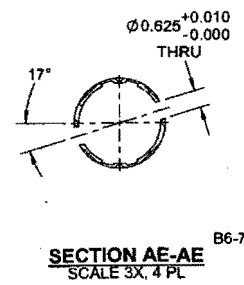
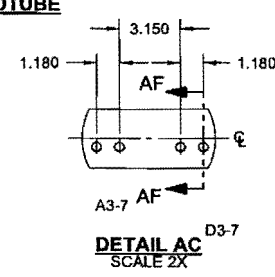
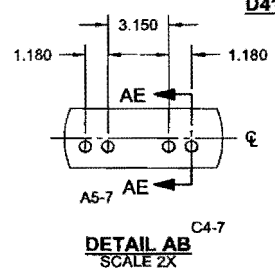
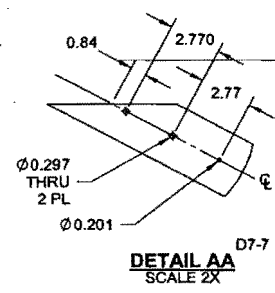
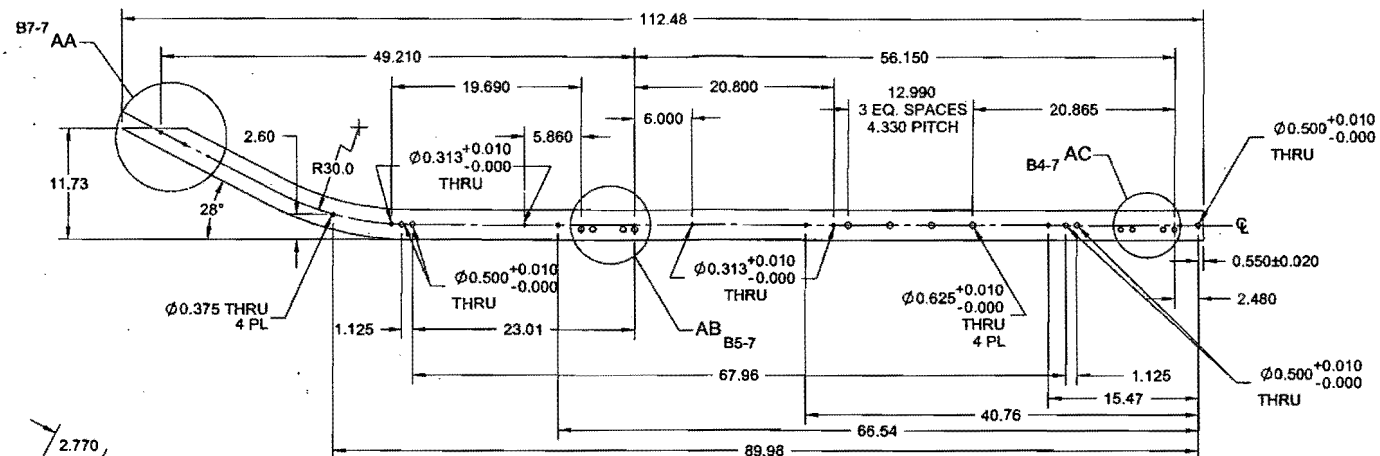
A

D

C

B

A



*al667180*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

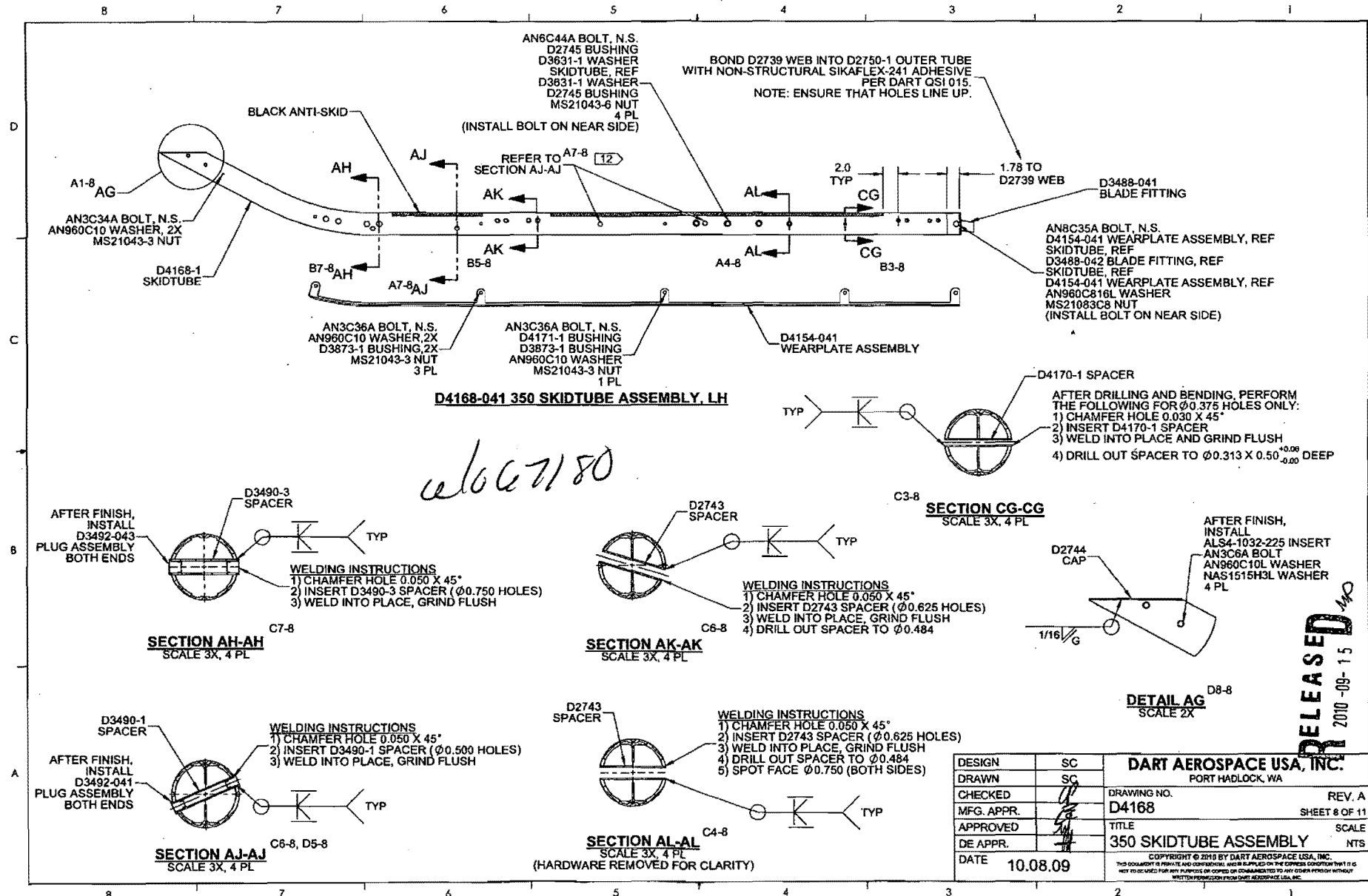
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
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APPROVED	SC	TITLE	SCALE
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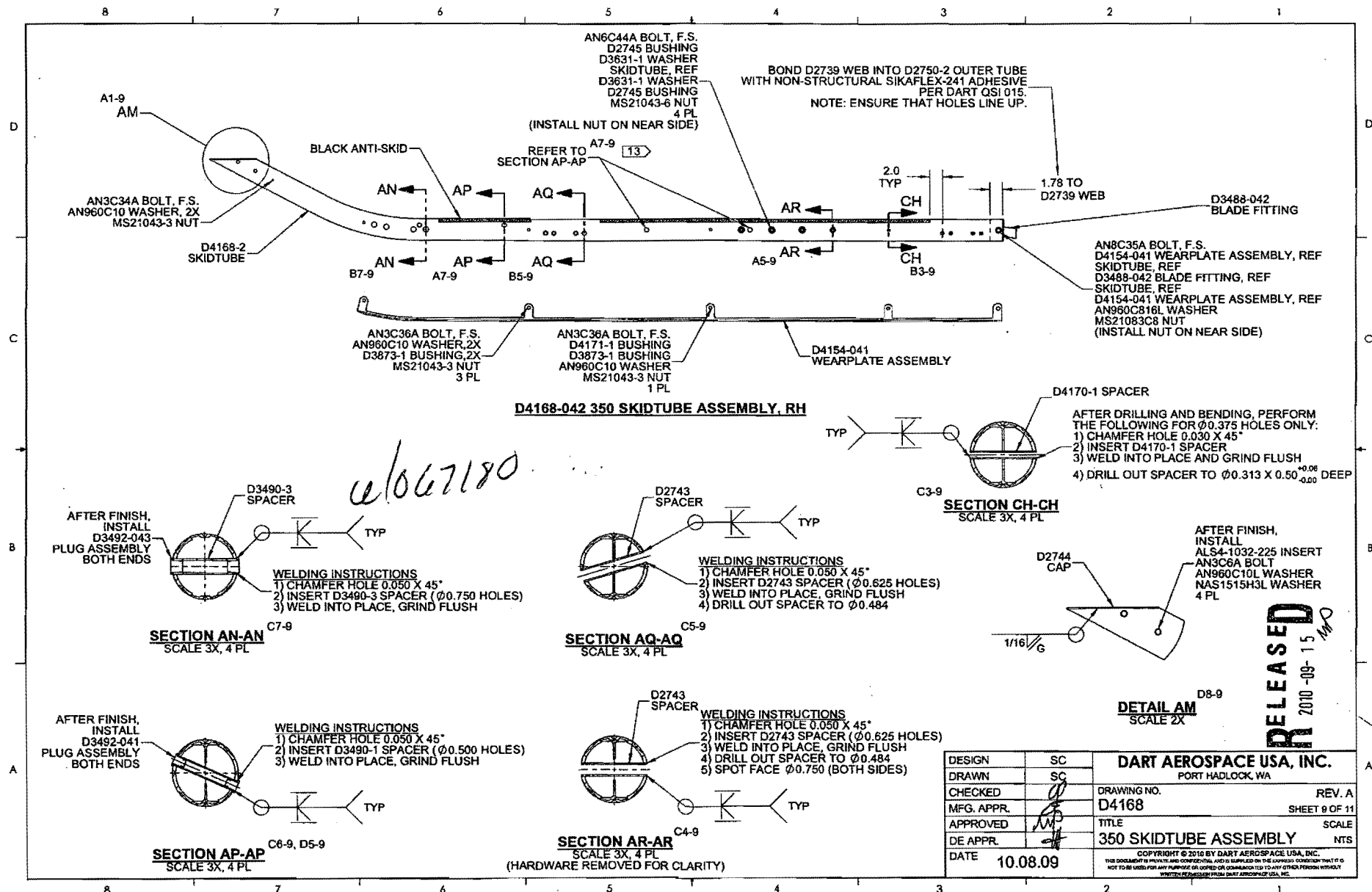
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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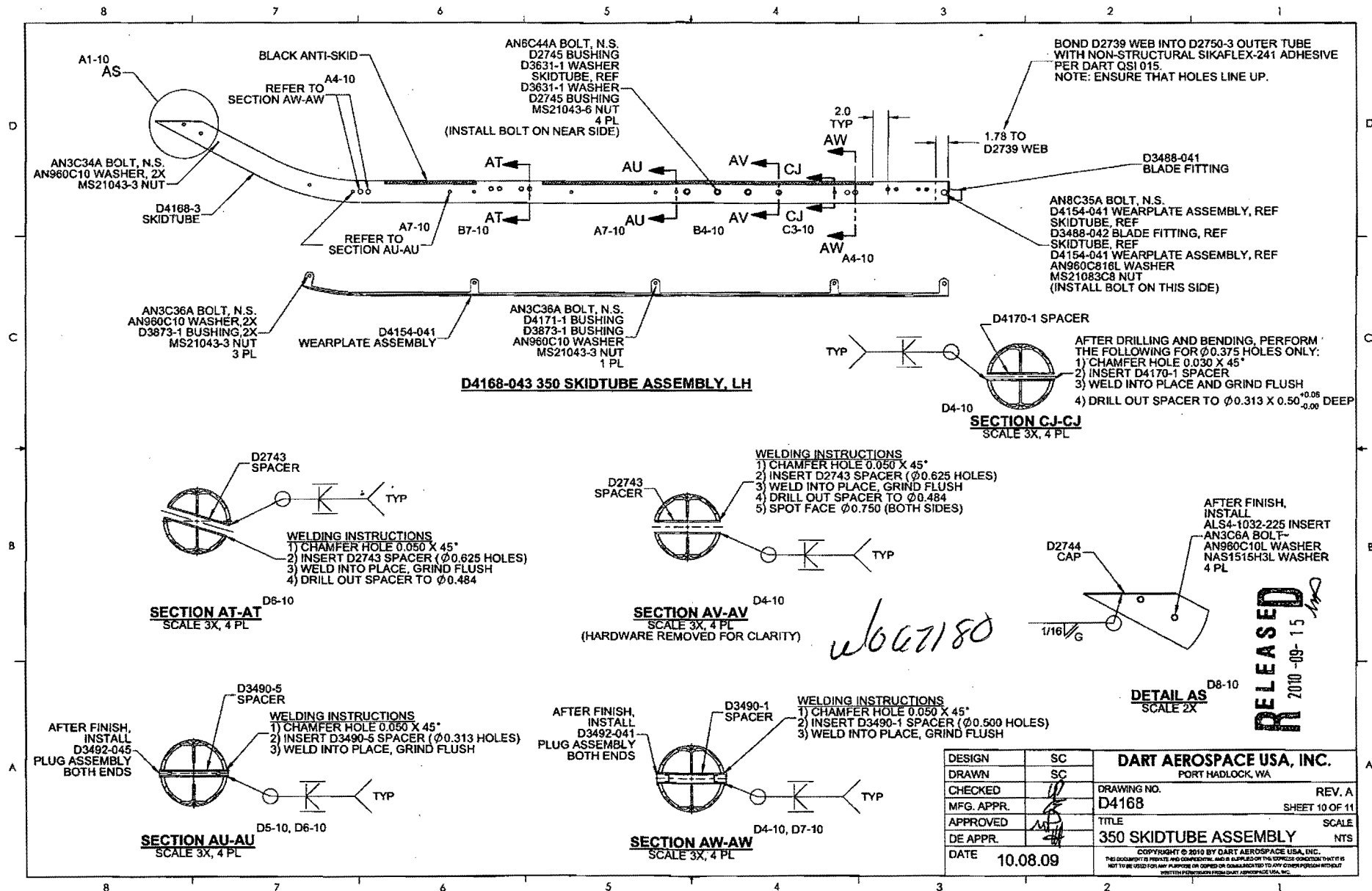
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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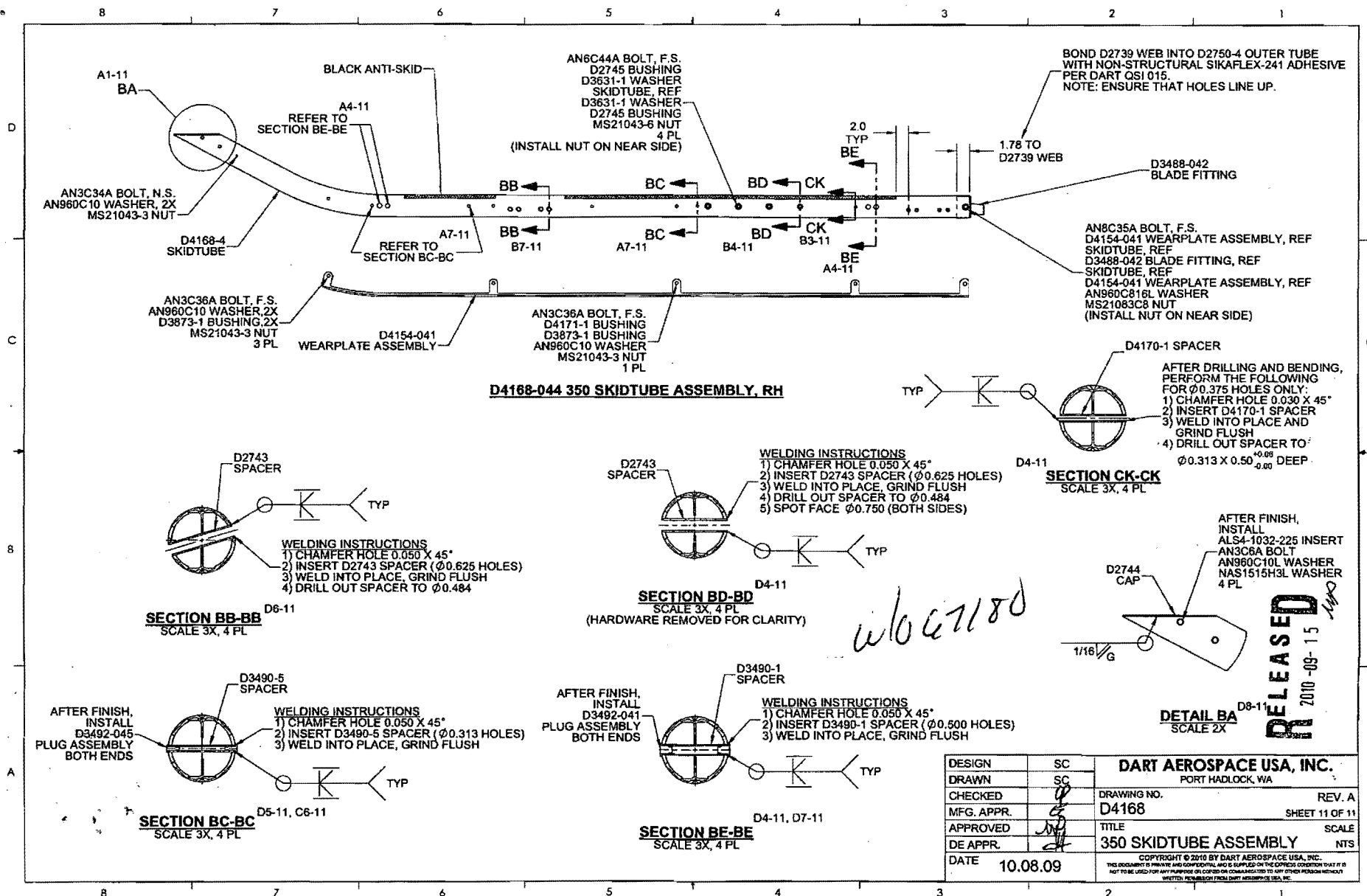
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 248

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 67178  
Part number: D350 636 015  
Description: 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Duggs Date of Test Coupon 11.04.05

Welder Barclay Elliott Date of Test Coupon 11.04.05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

